

Date: Wednesday, 4/4/2007 9:15:02 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	CUFF	
Job Number	31635		Part Number	D36061	
Estimate Number	12774		Drawing Number	D3606	
P.O. Number	N/A		Project Number	N/A	
This Issue	4/4/2007	S.O. No. : N/A	Drawing Revision	UNDER REVIEW 01C 07.04.04	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	4/30/2007	Qty: 20 Um: Each
Previous Run	31474				
Written By					
Checked & Approved By					
Comment	est rev A new issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R3500	Inventory D6061T6 Comment: Qty.: 0.5250 f(s)/Unit Total : 10.5000 f(s) 6061-t6 round bar 3.500" dia. batch: 329111
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE Comment: MORI SEIKI CNC LATHE LARGE 1-Turn as per folio FA & DWG D3606, FOLIO REV: _____ → new prog. DWG REV: A 2-Deburr as required
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/13
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 31635

Part Number: D36061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4/07/04/12 (21)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1 07.04.12

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4/07/04/13 (20)

Job Completion



✓ 4/07/04/13 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

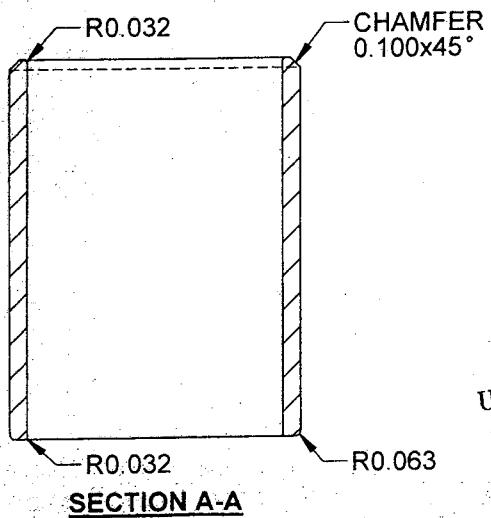
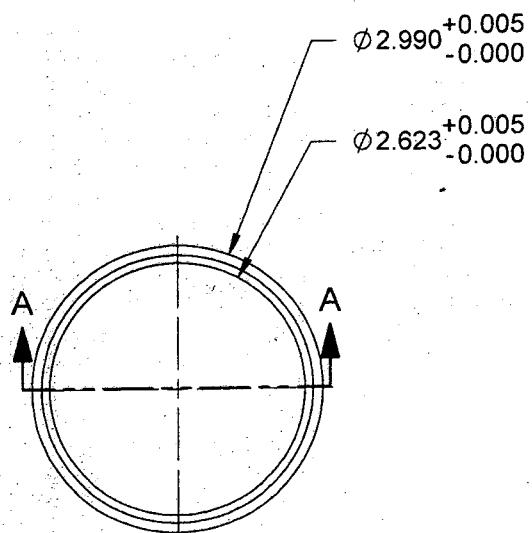
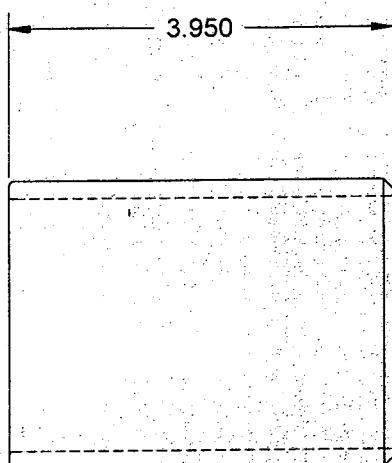
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	07.03.01	TITLE	SCALE
		CUFF	1:2

PRELIMINARY ISSUE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31635

D3606-1 CUFF**NOTES:**

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order:	31635
Description: Cuff	Part Number:	D36661 CUFF
Inspection Dwg: D3605	Rev:	A
		Page 1 of 1

~~FIRST ARTICLE INSPECTION CHECKLIST~~

x

First Article

Prototype

Measured by: <u>J. S</u>	Audited by: <u>M.S</u>	Prototype Approval:
Date: <u>07/04/09</u>	Date: <u>07/04/11</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	